

Work Order ID 83218

April-13-12 1:42:05 PM

83218

U/R

Page 1

Item ID: D4155-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Bar

Stop

NS2

Start Date: 13/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: M15

Date: 12/04/13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Form ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4155

B U/R

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 91.59"

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB048 & dwg D4155,

FOLIO REV: AA

DWG REV: C

2-Deburr as required

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83218

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Page 2

Item ID: D4155-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bar

Stop ***NS2***

Start Date: 13/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>W/A</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									

85 12-05-23 (16)

OK 12/05/26

16 x

(x16) ml 12-06-04

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Item ID: D4155-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bar

Stop ***NS2***

Start Date: 13/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/6/6 78

112068

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Picklist Print

April-13-12 1:42:09 PM

Page 1

Work Order ID: 83218

83218

Parent Item: D4155-1

D4155-1

Parent Item Name: Bar

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	509.9540	7.6333	128.5608			

M304B0 250x0 500

**

304 BAR .250 x .500

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT006	24.874	
120696	24.874	
MAT050	485.08	
121216	485.08	

M 121547 X128.6

on 12/05/12

W/O:		WORK ORDER CHANGES					
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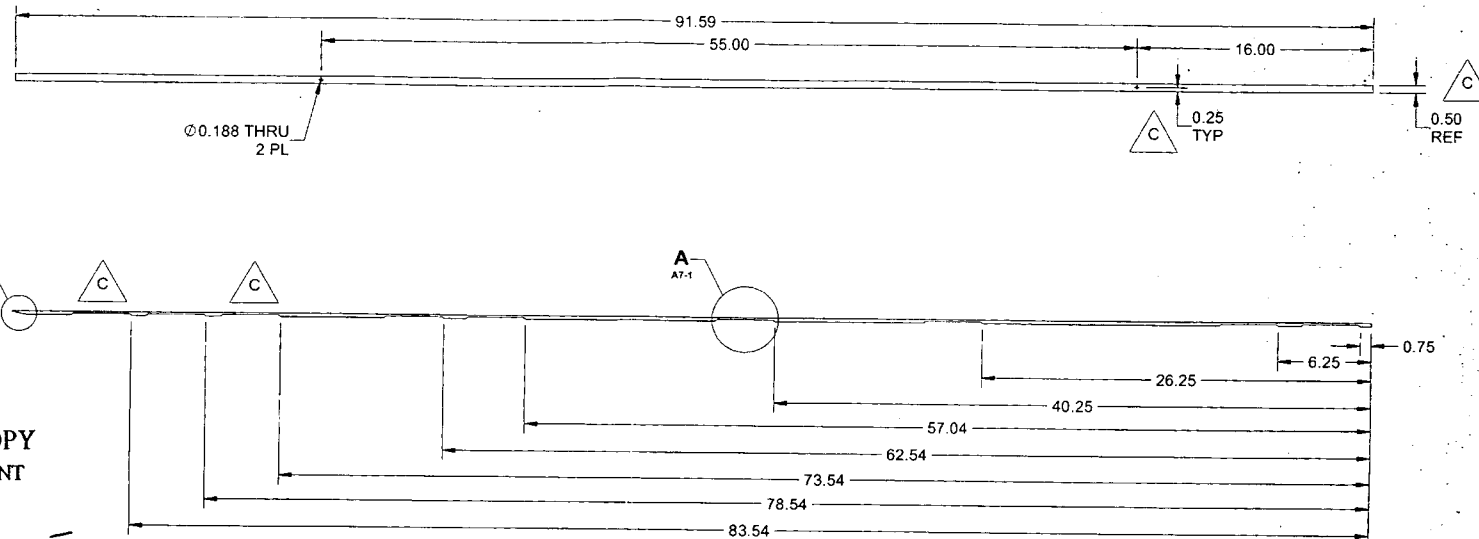
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

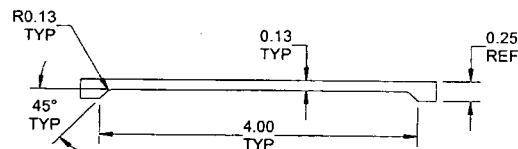
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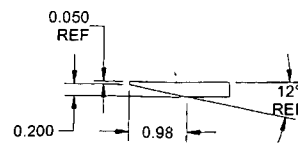
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83218 MLJ
12/04/13



D4155-1 BAR



DETAIL A D4-1
SCALE 2X, TYP



DETAIL B C7-1
SCALE 2X

REL
2012-04-11

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT: 2.69 lbs

C	REMOVED TOOLING HOLE; ADD CUT OUT PROFILE (ZN C6-1 & C7-1); 2 DEC TOLERANCE (D1-1, D2-1)	RF	12.02.21
B	CHANGED MANUFACTURING PROCESS; MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4155	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
DATE	12.02.21	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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